



Workmen's Compensation Act
Alberta

**SAFETY REGULATIONS
GOVERNING THE INSTALLATION
AND OPERATION OF WELDING
EQUIPMENT**

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The Workmen's Compensation Board
Edmonton, Alberta

This book is presented to

by

KNOWLEDGE AND CAUTION ARE THE BULWARKS OF SECURITY

Every workman should know the Accident
Prevention Regulations pertaining to his job

THE WORKMEN'S COMPENSATION BOARD

SAFETY REGULATIONS GOVERNING THE INSTALLATION AND OPERATION OF WELDING EQUIPMENT

GENERAL

1. (a) No employer or other persons shall authorize or order any employee or any subordinate who is not the holder of a valid certificate of proficiency as a welder to engage in or undertake any welding operation. (The Welding Act, 1941, C. 80, S. 10).

(b) No workman shall engage in or undertake any welding operation whatsoever, except he be the holder of a valid certificate of proficiency as a welder, covering that particular class of welding.

2. No operation of cutting, heating, or welding shall be commenced unless a fire extinguisher of suitable size to meet possible needs be readily accessible on the job. A dry chemical type of extinguisher is suitable for all such work. The extinguisher location shall be prominently marked.

3. Floors in all welding areas shall be kept free from debris, especially all inflammable materials.

4. (a) Hammers, chisels, punches, drills and other tools shall not be used if they have burrs or mushroomed heads.

(b) All tool handles shall be of sound material kept smooth and securely fastened in tool heads.

5. (a) Wheels used for grinding purposes shall be guarded with a hood which shall be strong enough to withstand the shock of a bursting wheel. This guard shall be adjusted close to the wheel and extended over the top to a point thirty degrees beyond a vertical line through the centre of the wheel.

(b) Rests used on grinder wheels shall not be set more than one eighth inch ($\frac{1}{8}$ ") from the face of the wheel, and shall be fastened securely in place. They shall not be adjusted while the grinder is in motion.

(c) Suitable goggles, having hard safety glass lenses shall be supplied by the employer and worn by the workman while working at abrasive wheels, or the wheel shall be equipped with extension guards with adequate steel frames and shatter-proof glass, which shall be kept in proper position whenever wheels are used. Goggles shall be worn at all times by workmen working at machines where two or more wheels are operating; whether fitted with glass guards or not.

(d) Goggles shall be worn at all times by workmen using buffing wheels, as also when using portable grinders.

(e) The speed of grinding wheels shall not exceed the speed recommended by the manufacturer.

6. Suitable close fitting goggles, gloves, and helmets shall be provided by the employer and worn by the workmen when cutting, welding, quenching or chipping, and/or working near such operations. Ragged or oil soaked clothes shall not be worn.

7. All hollow spaces, cavities or containers which may have been filled with combustible material shall be vented by drilling or other method to permit the escape of air or gasses before preheating, cutting, or welding. Purging with inert gas is recommended where possible. (See also Section 27.)

8. After welding operations are completed, the operator shall mark the hot metal or provide some other means of warning other workers.

9. In all cases where an operator is engaged in welding or cutting lead—or cadmium-coated metals or metals coated with lead, mercury, or cadmium-bearing paint or lead-bearing steels, an air-line respirator shall be used; where conditions do not permit their use, a filter-type respirator approved for protection from lead fumes may be used, but only for intermittent periods of work.

10. A jacketed vessel, tank or container shall not be welded until every possible precaution has been taken to vent the contained air. A metal part which is suspiciously light may be hollow inside and shall be drilled before heating.

GAS WELDING

11. 1. (a) Acetylene generators shall be of approved construction meeting the requirements of the Fire Underwriters Association. Acetylene generators shall not be used at rates producing cubic feet of acetylene per hour in excess of rates set out by the manufacturer of the generator. The manufacturers' name and address together with the type and number of the generator, shall be plainly marked on metal plates permanently attached to the generator, as shall also be the amount of carbide for a single charge. Complete detailed instructions for operation and maintenance of the particular type of generator shall accompany the generator at all times.

(b) Acetylene generators shall be operated only by a workman holding a valid certificate of proficiency for gas welding or a workman having passed a test on the operation and maintenance of acetylene generators to the satisfaction of the Workmen's Compensation Board.

(2) (a) Portable generators shall not be used in rooms of a total volume less than 35 times the total gas-generating capacity per charge of all generators in the room. Generators

shall not be used in rooms having a ceiling height less than 10'. (To obtain the gas-generating capacity in cubic feet per charge, multiply the pounds of carbide per charge by 4.5).

(b) Portable generators shall be cleaned and recharged and gas mixture blown off outdoors. They shall not be cleaned or recharged in the vicinity of any open flame, welder's arc, or other source of ignition. Generator residue shall not be drained into sewers where it may create a gas hazard.

(c) When charged with carbide, portable generators shall not be moved by crane or derrick.

(d) When not in use, portable generators shall not be stored in any room in which open lights or fires are used unless free of carbide and thoroughly purged of gas. Storage rooms shall be thoroughly ventilated.

(e) Portable generators shall be protected against freezing of water in generator and its attachments. Frozen generators shall be thawed out with hot water only. Ethylene-Glycol antifreeze may be used in the water seal only, in portable generators. No common salt (sodium chloride) or other corrosive chemical is permissible as a protection against freezing.

(3) (a) Stationary generators shall not be located in a room where welding is being done or where an open flame is used. Housing shall be well ventilated and of fire-proof construction. A sign reading, "CALCIUM CARBIDE DO NOT USE WATER IN CASE OF FIRE" shall be posted in a conspicuous place.

(b) Lighting for stationary generator rooms shall be from stationary lights, enclosed in vapour proof covers with rigid conduit. Switches and other electrical apparatus shall be located outside the room. Smoking in generator-rooms is prohibited.

(c) During freezing weather the building for stationary generators shall be heated by steam heat, hot water, or other indirect means.

(d) Water shall not be supplied through a continuous connection to the generator, except when generators are provided with an adequate open overflow or automatic water shut-off which will effectively prevent overfilling of generator. The supply pipe shall terminate not less than 2" above the regularly provided opening for filling so that the water can be observed as it enters the generator.

(e) Whenever repairs are to be made or the generator is to be charged or carbide is to be removed the water chamber shall be full during such operations to avoid the danger of explosion due to mixtures of air and gas within the water space and also to prevent dropping fresh carbide into insufficient water. Previous to making repairs involving welding, soldering or any hot work, or operation liable to produce a spark, all acetylene shall be expelled by completely flooding the generator shell with water and disconnecting the generator from the piping system. The water shall be maintained at as

high a level as work will permit. Where necessary to avoid wetting same, the carbide charge and feed mechanism shall be completely removed.

(f) The relief valves on stationary acetylene generators shall be of approved type, shall not be set at greater than fifteen (15) lbs.; shall be properly vented to the outside of the building and shall be tested once each week.

12. Calcium Carbide shall be stored only in a water-tight fire-proof room, other than a room in which men are regularly required to work.

Containers must have tight lids in place at all times. At all such storage rooms this sign must be prominently displayed—CALCIUM CARBIDE DO NOT USE WATER IN CASE OF FIRE.

13. (a) All manifolds shall be distinguished by a distinctive coloured paint and be stencilled with the word AIR, GAS, ACETYLENE, or OXYGEN, as the case may be at each outlet or control valve on the line. The colour Orange shall be used for acetylene, Green for oxygen, White for air, etc., according to the National Colour Code.

(b) In acetylene distribution systems where the gas is piped at a pressure in excess of one pound per square inch, an approved service regulator, check valve, or hydraulic seal shall be employed at every point where gas is withdrawn from the piping system to supply a torch or machine. A shut-off valve shall be installed at the inlet of each hydraulic seal, regulator, or check valve.

(c) The escape or relief pipe from hydraulic seals shall be at least as large as the vent connection on the hydraulic seal. The escape or relief pipe shall be substantially installed without low points where moisture may collect. If shop conditions make low points unavoidable, these points shall be provided with drip pots normally closed with valves fitted with a locking device so that they can only be opened by using the proper key.

(d) Outlet valves on pipeline systems shall be so located as to be easily accessible for hose connection.

(e) Tests of any piping systems or apparatus for leaks shall be made with grease-free soapy water and brush, never with flame.

14. (a) Pressure regulators used on oxygen, acetylene, or other gas cylinders shall be regularly examined and kept in repair. Leaking regulators shall not be used but shall be returned to the manufacturer for repair. Regulators shall only be used for the gas for which they are intended.

(b) A torch with leaking valves shall not be used. Care shall be taken to keep all valve packing tight and valves in good repair.

(c) All hoses used for cutting and welding shall be inspected by the welder or shop foreman at frequent intervals to determine their condition. If the condition of the hose is in

doubt, it shall be submerged in water and air-pressure fifty per cent above the working pressure applied. If air bubbles appear or if the hose is found to be in an unsafe condition, it shall be discarded or be repaired and tested again before it is used. Acetylene hoses shall be purged after testing with air before the torch is lit. Hoses shall be repaired only with the proper fittings and ferrules supplied by the manufacturer.

15. Materials giving off fumes shall not be burned without sufficient ventilation unless proper respirators are worn by all workmen exposed to fumes. Help or supervision shall be provided for burners or welders when working in a confined or cramped space.

16. Oil or grease shall NOT be permitted to come in contact with oxygen cylinders, valves, regulators, hose or other fittings. Oxygen cylinders and other apparatus shall not be handled with oily hands and greasy gloves. Oxygen valves are so constructed that they require no lubricant.

17. (a) Gas cylinders must be handled in suitable cradles when being moved by cranes, hoists or derricks. Gas cylinders shall not be handled by electro-magnets or in slings. When cylinders are transported by truck they shall be held securely in position. Cylinders shall not be dropped or permitted to strike each other vigorously.

(b) Cylinder valves shall be closed when work is finished and when cylinders are empty. Cylinder valve protecting covers shall be kept in position at all times that the cylinder is not connected for use.

(c) Every precaution shall be taken to prevent sparks or flames from welding or cutting torches coming in contact with cylinders, regulators or hoses. All charged cylinders shall be protected against undue absorption of heat from the sun, forges, or other sources. Charged oxygen and acetylene cylinders shall be stored separately from each other to avoid danger from mixture of leaking gasses.

(d) All workmen shall exercise extreme caution when opening any cylinder valve. Do not stand directly in front of the valve outlet or gauge faces if regulator is attached.

(e) If a leak should develop at a fuse plug or other safety device or on a gas cylinder, the cylinder should be removed to the out-of-doors well away from any source of ignition, the cylinder valve should be slightly opened and the gas allowed to escape slowly. No smoking or open flame should be allowed when this condition arises, and notices to this effect shall be posted. Such a cylinder should be plainly tagged, the owner notified, and his instructions followed as to its return.

18. An acetylene cylinder valve shall not be opened more than $1\frac{1}{2}$ turns of the spindle. The special wrench shall be left in position on the stem of the valve while the cylinder is in use, so that it can be quickly turned off in case of emergency. In the case of manifolded or coupled cylinders at least one wrench shall always be available for immediate use.

19. Under no conditions shall acetylene be generated or utilized at a pressure in excess of 15 lbs. per square inch gauge pressure. This is not intended to apply to the storage of acetylene dissolved in a suitable solvent in cylinders manufactured according to trade requirements.

20. When quenching hot metal the workman shall use only long handled tongs and a large quantity of liquid.

21. Cyanide compounds used for hardening processes are poisonous. Containers shall be conspicuously marked POISON and the antidote similarly printed on the container. Avoid contaminating hands or clothing with these compounds. Cyaniding processes shall only be carried on where there is ample ventilation of fumes.

ELECTRIC WELDING

22. No person shall engage in electric welding except he use a flip front type helmet containing a coloured glass between two protecting clear glasses to protect eyes and face. Only the flip front containing a first protecting glass and the coloured glass shall be raised leaving the second protecting glass in the helmet when chipping or cleaning the weld.

23. (a) Suitable protecting screens, at least six feet (6') high shall be installed in machine and welding shops for the protection of workmen who work or come near the flashes of arc welders, arc furnaces, and similar apparatus. Suitable portable screens shall be placed around the arc when arc welding is carried on in other locations. Welders and helpers shall be provided with and wear adequate helmets or goggles when exposed to glare.

(b) A welder shall do no welding where other workmen and the public may receive the flash of the arc unless such workmen and public are protected by proper goggles or protective screens are placed around the arc. These screens shall be provided to welders as part of their equipment, by employers.

24. Electrode holders shall be placed on an insulated rest or in some manner protected against grounding when not in use.

25. (a) Welding machines shall be shut down at all rest periods, ends of shifts and when changing the lines to new locations.

(b) When machines are not started or stopped by the welder, he shall be advised before same is done.

26. All welding equipment shall be thoroughly inspected at least once a month by a competent welder or foreman. Any and all such equipment showing excessive wear or weakness shall be immediately repaired or removed from service.

27. All barrels, tanks and containers, which may have at any previous time contained combustible substances shall

be subect to a thorough steaming before welding, altering, or repairing commences. Such steaming to be for a period of not less than thirty minutes for barrels and smaller containers, two hours for 500 gallon tanks, four hours for 1,000 gallon tanks and larger, using low pressure steam, during which time all covers and openings in the vessel shall be open. If possible the steam should enter at the bottom and escape at the top. The steam shall enter the vessel through a rubber hose or a spark proof metal nozzle only. Welding or repairing shall be carried out while the vessel is still warm with the steam.

28. (a) The supports of all elevated tanks shall be accessible for the purpose of inspection. Every tank over seven feet (7') deep containing liquids shall have a fixed ladder both inside and outside, except that tanks with fixed permanent covers, and with manholes within four feet (4') of the ground need have outside ladders only.

(b) When workmen are employed around open tanks, containing harmful substances, or open tanks four feet (4') or more in depth, the sides of such tanks shall extend at least thirty-six inches (36") above the working platform or a standard handrail shall be provided.

(c) Walkways over open tanks containing harmful substances or over tanks four feet (4') or more in depth shall be at least twenty inches (20") wide and equipped with standard handrails.

(d) Men walking on tank roofs shall use planks to increase the bearing surface on which they walk.

29. (a) Before any work commences on closed vessels such as storage tanks, towers, stills, fractionating equipment, etc., they shall first be entirely blanked off by the insertion of steel plates between the pipe connecting flanges nearest the vessel on inlet and outlet lines. The closing of double valves on any line will not be accepted as a substitute.

(b) No workman shall enter any tank, vessel or chamber that may contain toxic fumes or gasses until it has been ascertained that the air contained therein is sufficiently pure. In doubtful cases air supply respirators and life lines shall be used by workmen entering such places, and another workman shall be stationed at the entrance to assist those that may become distressed.

(c) Large capacity tanks shall be steamed with low pressure steam until such time as the entire tank is warm and steam vapour flows continuously out of the upper opening. Only steam hose as described in Section 27 shall be used in these operations. Upon completion of the steaming, welding or repairing may be commenced subject to the tests as set out in the immediately preceding paragraph. All work shall be completed while the tank is still warm and while there is still steam in the tank.

(d) Using air in tanks shall be permissible only as an indirect means of extracting fumes from the tank. The hose is to be directed out of the manhole from only a few inches

inside the tank in such a manner that it creates a partial vacuum around the manhole area and so draws the contents of the tank out. Oxygen shall never be used for this purpose under any condition.

30. Where these regulations do not provide suitable protection against injury or industrial disease to workmen employed in industry, the Board may direct or approve of any changes found necessary.

31. All previous regulations issued by the Board prior to this date applying to the installation and operation of welding equipment are hereby repealed."

EXTRACTS FROM THE WORKMEN'S COMPENSATION ACT

Section 15 (1) The Board shall have power,—

- (a) to investigate from time to time employments and places of employment within the Province, and determine what suitable safety devices or other reasonable means or requirements for the prevention of accidents shall be adopted or followed in any or all employments or places of employment;
 - (b) to determine the requirements for safe working conditions including the proper sanitation and ventilation of the employer's premises;
 - (c) to determine what suitable devices or other reasonable means or requirements for the prevention of disease shall be adopted or followed in any or all employments or places of employment;
 - (d) to make regulations whether of general or special application and which may apply to both employers and workmen, for the prevention of accidents and the prevention of diseases and for the provision of safe working conditions including proper sanitation and ventilation in employments or places of employment.
- (2) The Board or any member thereof or any officer or person authorized by it for that purpose may at any time enter into the establishment of any employer who is liable to contribute to the Accident Fund and the premises connected with it and every part of them, for the purpose of ascertaining whether the ways, works, machinery or appliances therein are safe, adequate and sufficient and whether all proper precautions are taken for the prevention of accidents to the workmen employed in or about the establishment or premises and whether the safety appliances or safeguards prescribed by law are used and employed therein and whether the working conditions, including sanitation and ventilation, are safe or for any other purpose which the Board may deem necessary.
- (3) Where, in any employment or place of employment, safety devices are in the opinion of the Board, necessary for the prevention of

accidents or of disease, the Board may order the installation or adoption of such appliances or devices and may fix a reasonable time within which they shall be installed or adopted, and the Board shall give notice thereof to the employer and the employer shall post or cause to be posted, in a conspicuous place upon the place of employment a copy of the notice, which shall remain so posted until the order has been complied with and the employer so notifies the Board and the Board has authorized its removal.

(3a) When the employer, having been so ordered, fails to notify the Board within the time fixed by the order for so doing, of his having complied with the order, the Board may, at such time or times as it deems advisable, inspect or have inspected the premises of the employer and ascertain whether or not the order has been complied with and the Board may charge the cost of the inspection to the employer who shall be liable to the Board therefore.

(4) In any case where safety devices or appliances are by order of the Board required to be installed or adopted or are prescribed by the regulations and the employer fails, neglects or refuses to install and adopt such safety devices or appliances in any employment or place of employment to the satisfaction of the Board, or where under the circumstances the Board is of the opinion that conditions of immediate danger exist in any employment or place of employment which would be likely to result in injury to any person, the Board may, in its discretion, order the employer forthwith to close down the whole or any part of such employment or place of employment and the industry carried on therein and the Board shall notify the employer of the order and a copy of the order, to be provided by the Board, shall, if the Board so requires be posted by the employer in a conspicuous place upon the employer's premises:

Provided that nothing herein contained shall take away or abridge any of the powers and duties of the Provincial Board of Health or local boards of health, as constituted under The Public Health Act:

Provided further that the Board or any member of it or any officer appointed by it may

forthwith report to the Provincial Board of Health any breach of the Public Health Act or regulations of the Provincial Board of Health passed under the said Act.

- (5) Where an accident causing injury to a workman in respect of which compensation is payable has occurred and where, in the opinion of the Board, the accident was due entirely or mainly to the failure of the employer to comply with the directions of the Board or with the regulations made under this Act, the Board may levy and collect from the employer as a contribution to the Accident Fund, a sum of money not exceeding one-half of the amount of the compensation payable in respect of the injury and the payment of such sum may be enforced in the same manner as the payment of an assessment may be enforced.
- (6) Where in the opinion of the Board sufficient precautions are not taken for the prevention of accidents to the workmen in the employment of any employer or where the working conditions are not safe or the first aid requirements provided by the Act or regulations have not been complied with, the Board may add to the amount of any contribution to the Accident Fund for which the employer is liable, such a percentage thereof as the Board may deem just and may assess and levy the same upon the employer.
- (7) The powers conferred by the next preceding subsection may be exercised from time to time and as often as in the opinion of the Board occasion may require.
- (8) The Board, if satisfied that the default was excusable, may in any case relieve the employer in whole or in part from liability under this section.

- Section 16 (1) No employer shall, for the purpose of any industry within the scope of this Act,—
- (a) commence the operation of any mine, plant or establishment in which power-driven machinery is used; or
 - (b) recommence the operation of any mine, plant or establishment in which power-driven machinery is used, which has been out of operation for more than seven months last preceding;
until leave therefor is obtained from the Board in the manner provided in subsection (2).

- (2) Application for leave under this section shall be made to the Board in writing, signed by the employer, stating that the mine, plant, or establishment is ready for operation. Upon receipt of the application, the Board or some member of the Board, or some other person appointed by the Board for that purpose, shall make an inspection of the mine, plant or establishment and if on such inspection the mine, plant or establishment is found to be reasonably free from danger to persons employed therein, the Board shall grant leave for the operation of the mine, plant or establishment. Pending inspection, the Board may, by a temporary permit, grant leave to the employer for the operation of the mine, plant or establishment.

Section 17 (1) The Board shall engage in and carry on the education and instruction in accident prevention and first aid work of workmen and others and may impart such education and instruction by demonstration, exhibits, lectures, classes or otherwise and shall hold examinations and issue certificates to persons whom it may deem sufficiently skilled in such matters as to warrant the issue to them of such certificates.

- (2) Certificates issued by the Board under subsection (1) thereof may be cancelled by the Board at any time when, in its opinion the holder thereof does not continue to have the necessary qualifications in accident prevention and first aid work.

Section 45 (1) Employers, whenever required by the Board so to do, shall at their own expense, install, maintain and provide, such first aid appliances and service as the Board may direct and after having done so shall advise the Board accordingly.

Section 45 (2) Every employer shall keep in a book provided and kept for that purpose only, a record of all cases in which first aid treatment has been given to a workman for or in respect of any injuries suffered by him, and the record shall set out the name of the workman, the nature of the injuries, the date they were suffered, the date they were treated and the nature of the treatment, together with the name and address of the person giving the treatment, and every such book shall be open at any and all times to inspection by the Board or any member or representative thereof or by an injured workman concerned or by his representative.

ACCIDENT PREVENTION COMMITTEE REGULATION

Every manufacturing plant, construction camp, workshop or other undertaking within the scope of the Workmen's Compensation Act shall, where ten (10) or more workmen are employed, have an Accident Prevention Committee of not less than two (2) members. Provided in respect to employment under Schedule 1, the Accident Prevention Committee appointed under these regulations shall apply only to operations above ground.

The general duties of the Accident Prevention Committee shall be:

- (a) To make a thorough inspection not less than once a month of the entire plant, or place of employment for the purpose of receiving complaints, determining hazardous conditions, and receiving recommendations for their improvement.
- (b) To hold regular meetings at least monthly for the discussion of Accident Prevention, to investigate all serious accidents, reporting their findings and recommendations in writing to their employers and keeping a copy of such findings and recommendations in the records of the committee which shall be available at any time to the Workmen's Compensation Board or its officers.

The report of the findings and recommendations of the Accident Prevention Committee shall be made monthly in triplicate on forms provided by the Board, one copy being handed to the employer immediately after the findings have been given, one copy being immediately forwarded to the Board and the third copy being kept by the committee.

- (c) To educate their fellow-employees against dangerous practices and methods of work.
- (d) To investigate fire conditions, examine fire-escapes, fire-extinguishers, water-buckets, sand buckets and all fire fighting appliances.
- (e) To inspect lighting arrangements in all places of employment, and to report to the employers all insufficiently-lighted passages and other places where workmen are liable to be injured in the course of their employment.
- (f) To inspect or to arrange for the inspection of all machinery, transmission motor-stops, cables, blocks, slings, chains, tongs, tools and equipment.
- (g) To provide at each establishment facilities for receiving written complaints and recommendations.

**SAFETY REGULATIONS COVERING INDUSTRIES
COMING WITHIN THE SCOPE OF THE
WORKMEN'S COMPENSATION ACT ARE AVAILABLE
AS FOLLOWS:**

CONSTRUCTION — Building and General Construction,
Alteration, Demolition, Excavations.

DUST—Regulations respecting the control of Dust.

EXPLOSIVES—Storage, Handling and Firing of Explosives.

FIRST AID—First Aid Regulations.

GARAGES—Motor Vehicle, Repair Shops, Service Stations
and Garages.

WELDING—Governing the Installation and Operation of
Welding Equipment.

GRAIN ELEVATORS—Governing the Construction, Operation
and Maintenance of Machinery and Equipment in Grain
Elevators.

LAUNDRY—Laundry and Dry Cleaning Machinery.

MACHINERY—Governing the Installation and Operation of
Power Transmission Machinery and Equipment.

GAS AND OIL WELLS—Construction, Operation and Main-
tenance of Gas and Oil Well Drilling Plants, Rigs and
Equipment.

SEISMOGRAPH—Applying to the Storage, Handling, Trans-
portation and Firing of Explosives.

ACCIDENT PREVENTION COMMITTEE—Required where
ten or more workmen are employed.

SAWMILLS—Logging, Sawmill and Woodworking.

TRENCH CONSTRUCTION AND REPAIRS—These Regula-
tions also apply to Shaft Sinking and Sewer Construction
and Repair.

WATER WELLS—Digging, Drilling, Cleaning or Repairing
of Water Wells.

Copies of these regulations can be secured on request.

Cards for posting on the premises, instructing workmen to
report all injuries immediately and secure first aid treatment,
are also available.

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